

Work Order ID 119941***119941***

Page 1

May-30-14 8:42:29 AM

Item ID: D206-642-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-05-30

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F(DEO)

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-642-241

CHG007

N/A MLJ 1503-09

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119941

Page 2

Item ID: D206-642-241 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear(Fits LH or RH)
 Start Date: 5/30/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650.

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number DescriptionBatch

A/R Aluminum Rod *m125127/m127763*

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

> 14-6-2

> 14-6-03

DGL 14-6-3

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Item ID: D206-642-241 Accept *N9000040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.								
	12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650								
	13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder								
	14-Remove indexing edge using DT8741 as per Dwg D2650								
	15-C'sink GHW rivet holes as per Dwg D2650								
	16-Open crossbolt holes to Ø0.3125"								
	17-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.								
	18- Ream crossbolt spacer holes to finished size as per Dwg D2650, D2650-3 Drilling Detail ***DO NOT OPEN X-BOLT SPACER HOLE OF DETAIL B***								
	19-Deburr tube as per QSI 018 and blow out chips from inside the tube								

DAC 14-6-3

DC 14/06/17

9779
DAS
10
988

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Item ID: D206-642-241

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Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC7-Inspect Chemical Conversion Coat 0.00

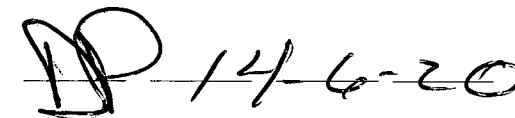
150

QC

Memo

0.00

Quality Control



160

0.00

160

Skidtubes

Skidtubes

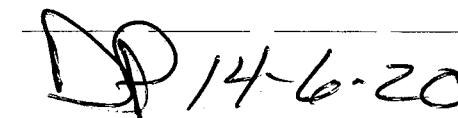
Memo

0.00

Skidtubes

1- Open and c'sink one crossbolt spacer holes as per Dwg D2650 (DEO Detail B)(without cutting fluid)

2-Deburr and blow out all chips from inside the tube



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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

Skidtubes

Skidtubes

Skidtubes

Memo

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

Start Date: 14-6-20 Time: 1030AM

Finish Date: _____ Time: _____

Pick:

Qty Part NumberDescriptionBatch

A/RSikaflex-291 129457

Sikaflex expire date: 14-11-20

 14-6-20

**DAS
18
9-89**

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

1 14-06-23

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Item ID: D206-642-241

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N900040100

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Required Date: 5/30/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00

200

Skidtubes

0.00

Skidtubes

Memo

1-Remove alodine in one area per DEO detail B from around hole and prepare for welding

2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M125/2 7

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

6-Install D2680-041 Nut Plate as per Dwg D2650

BE 14-06-23

DGC 14-6-23

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
220									DAS
QC	Memo	0.00							8
Quality Control									9-88
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								

DAS
27
9-89

14/6/25

① 14-06-24

1 7/8 14-6-27

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Item ID: D206-642-241

Accept

N900040100

Setup Start

NS1

Revision ID:

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NS2

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Start Date: 5/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

0.00

Powder Coating

Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

11128959

START TIME: 10:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30A

12 6 22 10/08/11

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

1 14-8-11

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119941

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Item ID: D206-642-241 Accept *N900040100* Setup Start *NS1*
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00							
270	HandFinish	0.00							
Hand Finishing	Memo 1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>14129457</u> Sikaflex expire date: <u>14/11</u> 2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive. 3-Install MS27039-4-06 Screw as per DEO 9153. <u>RTV 598 11125792 exp 15/06</u> 4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>14129457</u> Sikaflex expire date: <u>14/11</u> 5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4 A/R Batch: <u>14129817</u>								
300	QC5- Inspect part completeness to step on W/O	0.00							
300	QC	0.00							
Quality Control	Memo								

DAS
38
9-89

14-8-27

DAS
38
9-89

14-8-27

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119941

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Item ID: D206-642-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

310

0.00

310

Packaging

68-6
90
SVG

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-241

Location: _____

PPP Rev: _____

MAR 06 2015

320

0.00

320

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MJS 1503-06

① 15-3-6

Picklist Print

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Page 1

Work Order ID: 119941

119941

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 Revised procedural stepsKJ/JLM IPP RevP: revise
and update route/bom DD 10.01.06 verf:ECIPP rev Q 10.02.19 per PAR
09-043 EC verified by: DD IPP Rev:R 12.11.22 now swage per ecn12-
679 DD verf:JLM IPP Rev:S 14.04.24 ECN14-520 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4956-13 *D4956-13* Wearshoe		Manufactured	No				Each	0.0000		1	**	B120491(1x) all 11/08/20	
D4956-21 *D4956-21* Wearshoe		Manufactured	No				Each	0.0000		1	**	B120328(1x) all 11/08/20	
D4956-33 *D4956-33* Wearshoe		Manufactured	No				Each	0.0000		1	**	B123563(1x) all 11/08/20	
D2620 *D2620* Skidtube, 206 Skidtube		Manufactured	No			110	Each	13.0000	1	1	**	DD 14-6-2	

Location	Loc Qty	Loc Code
LG	10	
115831	10	
LG002	3	
114467	3	

Picklist Print

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Work Order ID: 119941

119941

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D4720-1 Manufactured No 200 Each 699.0000 17 17

D4720-1

Spacer

Location	Loc Qty	Loc Code
LG	673	
114878	673	
LG001	26	
103902	3	
113686	23	

17 DGL 14-6-23

D3286-1 Manufactured No 110 Each 61.0000 2 2

D3286-1

Doubler

Location	Loc Qty	Loc Code
LG001	61	
91158	61	

2 DGL 14-6-3

D2647 Manufactured No 110 Each 39.0000 1 1

D2647

Cap

Location	Loc Qty	Loc Code
LG	39	
114961	39	

1 BE14-06-02

D2654-3 Manufactured No 180 Each 3.0000 1 1

D2654-3

Web

Location	Loc Qty	Loc Code
LG	3	
112279	3	

1 DP 14-6-20

1

Picklist Print

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Work Order ID: 119941

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Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

598.0000

52

52

CR3212-4-04

Cherry Rivet

**

DP 14-6-20

Location

Loc Qty

Loc Code

ST327

28

123265

28

st552

570

m126534

10

m128228

560

D2649

Manufactured

No

200

Each

394.0000

1

D2649

Cross Bolt Spacer

**

BE 14-06-23

Location

Loc Qty

Loc Code

LG

264

112728

58

113811

206

LG001

130

107906

3

108633

121

90497

6

D3286-3

Manufactured

No

200

Each

99.0000

2

2

D3286-3

Spacer

**

BE 14-06-23

Location

Loc Qty

Loc Code

LG001

99

109097

61

91160

38

2

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D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each

44.0000

1

D2680-041******

Nut Plate

LocationLoc QtyLoc Code

LG

44

110751

19

115056

25

①

DGC 14-6-23.

CR3212-4-03

Purchased

No

Each

1,069.000

2

CR3212-4-03******

Cherry Rivet

LocationLoc QtyLoc Code

ST327

969

114889

1

119017

700

m123265

268

st552

100

m114859

100

②

DGC 14-6-23

CCR264SS3-3

Purchased

No

Each

483.0000

2

CCR264SS3-3******

Cherry Rivet

LocationLoc QtyLoc Code

ST327

483

113973

26

m126282

49

m126333

108

m128636

100

m128818

200

②

DGC 14-6-23

②

DGC 14-6-23

May-30-14 8:42:33 AM

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Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No 270 Each 64.0000 1 1

D2646

Aft Cap

ell 11/08/26

Location

Loc Qty

Loc Code

FG	4	
85848	2	
90495	2	
FP001	60	
103306	5	
107857	1	
110816	13	
113830	31	<i>x1</i>
114495	10	

D2651-1 Manufactured No 270 Each 400.0000 18 18

D2651-1

Plug

ell 11/08/26

Location

Loc Qty

Loc Code

FP001	400	
104843	1	
106456	11	
111875	44	<i>x18</i>
112725	202	
114496	142	

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Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

270

Each

5,661.000

1

1

NAS1149D0463.J

WASHER

all 11/08/26

Location

Loc Qty

Loc Code

ST510a

5661

16941

8

1123390

21

M124778

18

M126221

20

M127813

22

M127904

3000

M128591

1093

M128995

1500

D2651-3

Manufactured

No

270

Each

628.0000

18

18

D2651-3

O-Ring

all 11/08/26

Location

Loc Qty

Loc Code

FP001

628

104725

8

108583

26

112214

100

113577

494

118

MS27039-1-08

Purchased

No

270

Each

2,079.000

46

46

MS27039-1-08

Screw

all 11/08/26

Location

Loc Qty

Loc Code

GA

3

m125654

3

ST305

2076

m128636

2076

116

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Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 AELS4-1032-130 Purchased No

270 Each 7,644.000 44 44

ALS4-1032-130

Rivnut

all 14/08/20

Location

Loc Qty

Loc Code

FP001

7539

M128649

7539

ST279

48

M128211

48

st510

57

M126109

57

MS27039-4-06 Purchased No

270 Each 61.0000 1 1

MS27039-4-06

Screw

all 14/08/20

Location

Loc Qty

Loc Code

ST306

61

m126534

61

NAS1149D0332J Purchased No

270 Each 3,506.000 46 46

NAS1149D0332J

Washer

all 14/08/20

Location

Loc Qty

Loc Code

ST294

421

m128606

421

ST510a

3085

m128612

3085

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Picklist Print

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Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 270 Each 37.0000 4 4

D3537-1

Wearpad

ell 14/08/20

Location

Loc Qty

Loc Code

FG	18	
79833	8	B120645
88562	10	✓4
FP001	19	
113229	6	
113358	8	
113839	4	
93945	1	

D3537-3 Manufactured No 270 Each 49.0000 1 1

D3537-3

Wearpad

ell 14/08/20

Location

Loc Qty

Loc Code

FG	8	
86237	8	
FP001	41	
113789	1	
115122	24	KL
115123	16	

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

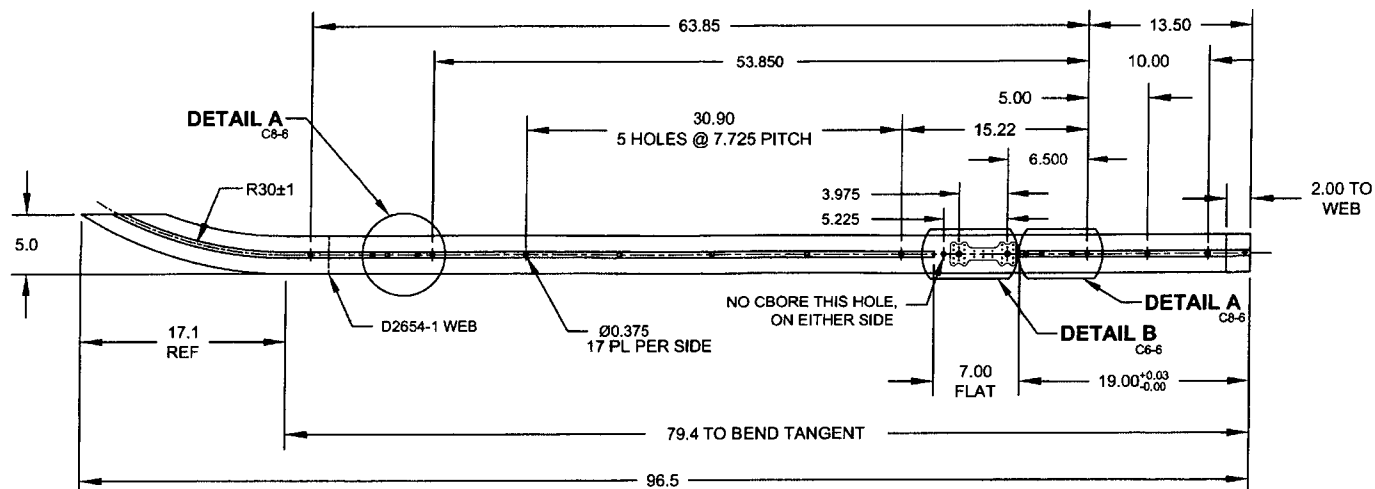
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119941 MJS

11-05-30

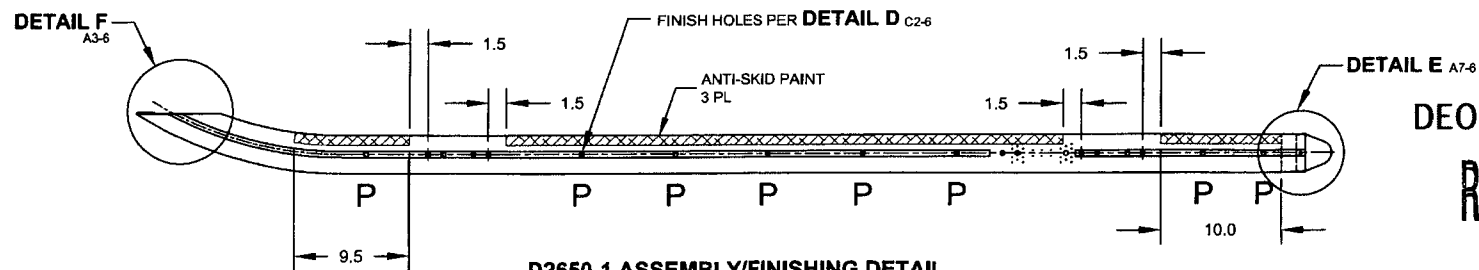
DEO ATTACHED

RELEASED
08-27-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



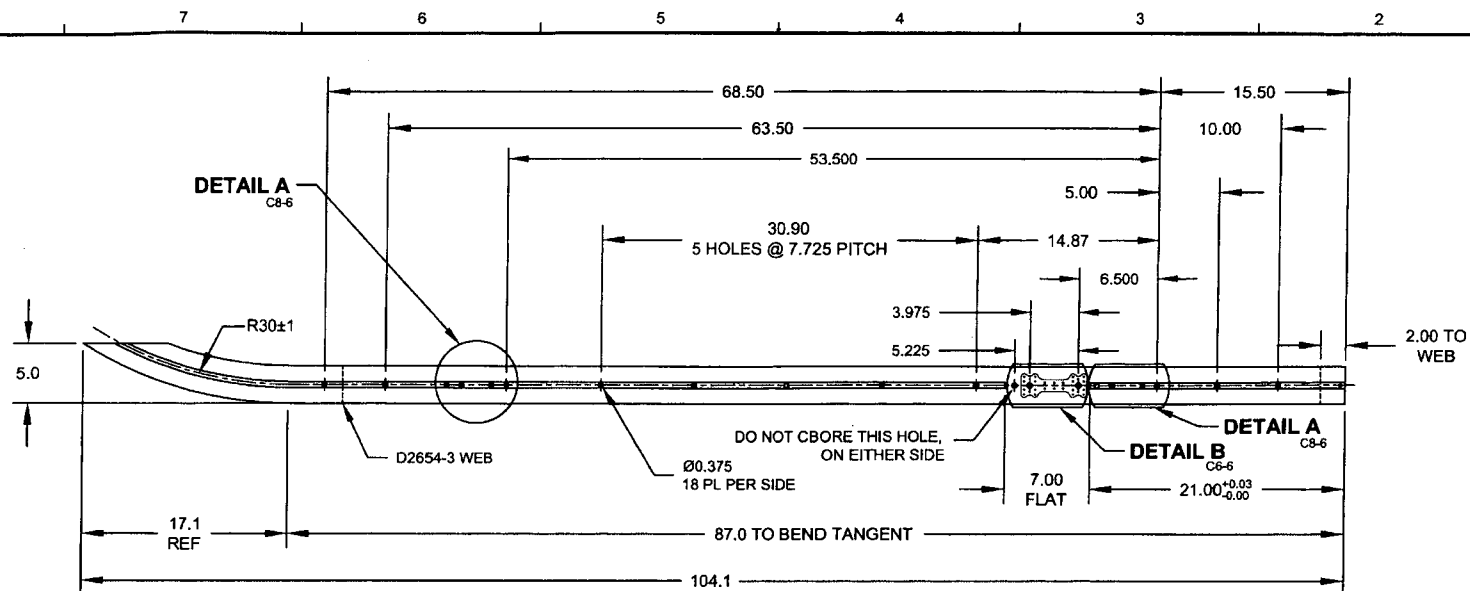
D2650-1 BENDING/DRILLING DETAIL



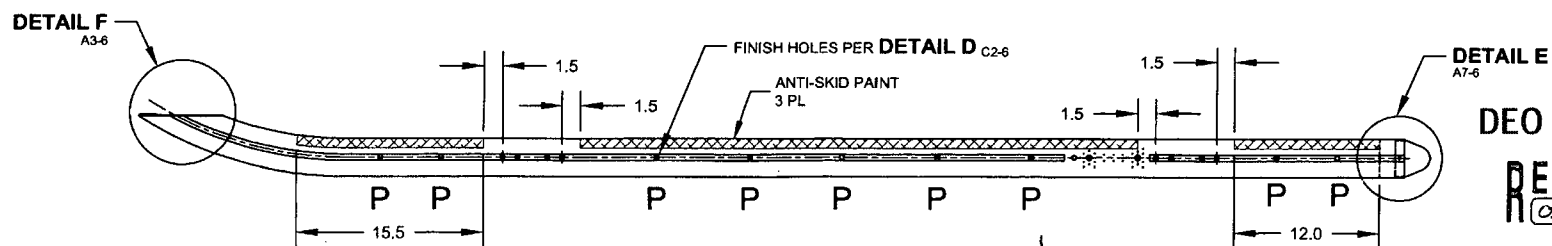
D2650-1 ASSEMBLY/FINISHING DETAIL

DEO ATTACHED
RELEASED
620922/117

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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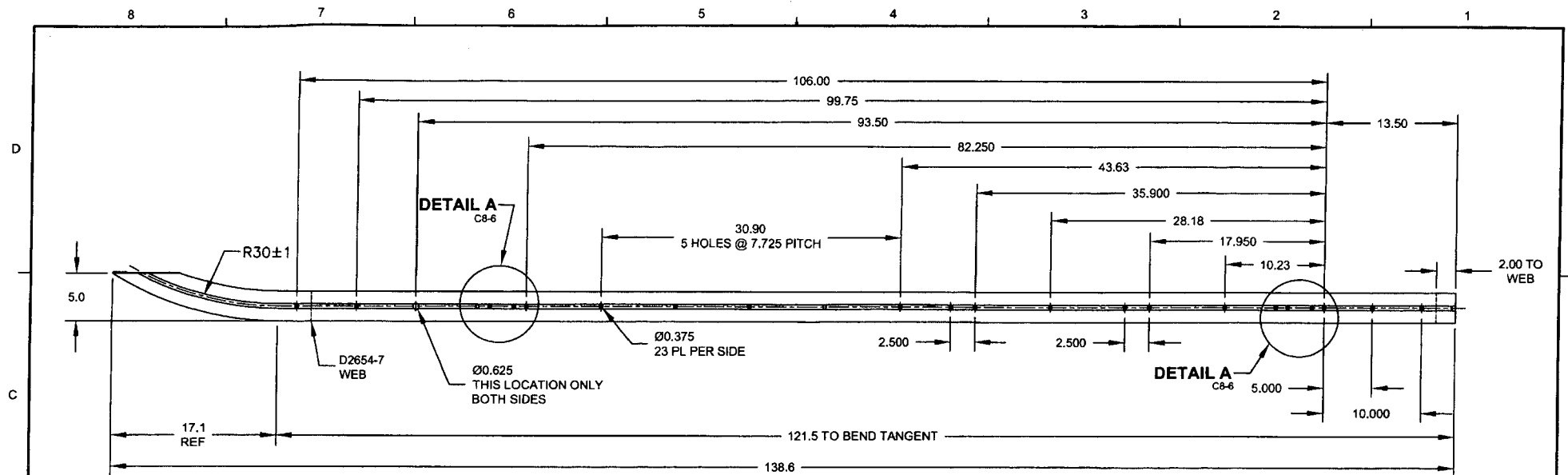
D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

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08 07 22 118

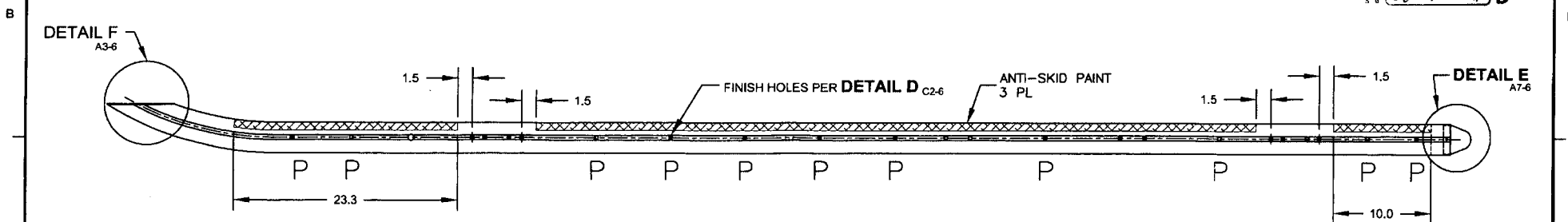
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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D2650-7 BENDING/DRILL DETAIL

DEO ATTACHED

RELEASED
08 07-22/11



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

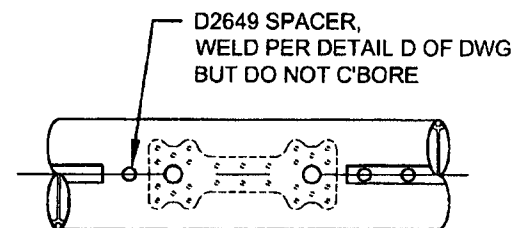
QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

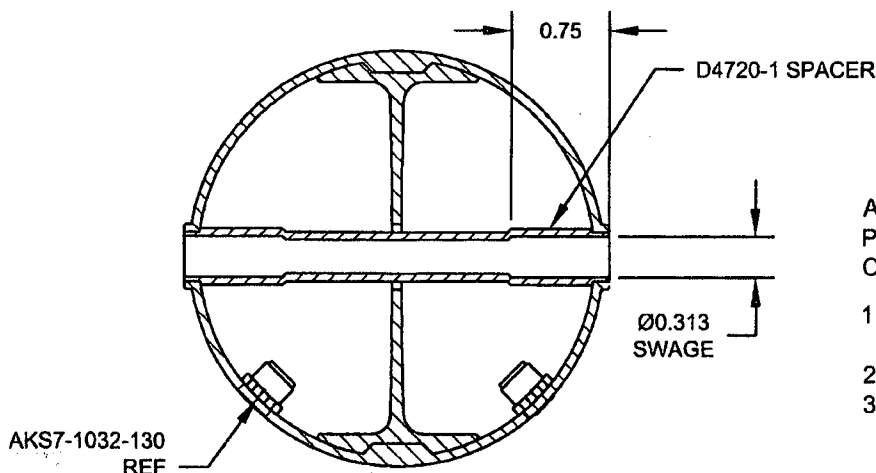
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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PAR 14-338
Patrick Smith
May-29-14 1:29 PM
Linda Lacelle; Mike Petsche
Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
RE: 350 skids and 206 skids

David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

Plugs would require:
Removal from the Skidtube
Removal of the current O-Ring
Cleaning with Alcohol
Installation of NEW O-Ring
Continuous coating of the RTV
Insertion of plug into the Spacer
Sealing up of exterior of Skidtube.

Lacelle
May-29-14 10:21 AM
Mike Petsche
Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod
RE: 350 skids and 206 skids
Status: High

Yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution
Let the customer know if his order is shipping or not...

elle

Mike Petsche
June-24-14 3:17 PM
Linda Lacelle
RE: D206-642-541 floats

I say just assemble them. The powder coat won't last long anyway

a Lacelle
day, June 24, 2014 12:40 PM
tsche; David Shepherd; Chris Provencal
rbes
E: D206-642-541 floats

ed with assembly? We have about 10 on the go right now. I really don't want to wait to have more made...we have 79 of the painted in stk of D3537-
the D3537-3's. shall I get all the w/o's off the shop floor and remove the powder coat? Do I need someone to sign this off?

Petsche
24-14 12:38 PM
acelle; David Shepherd; Chris Provencal
rbes
E: D206-642-541 floats

eally. But ideally we should remove the powder coat from the dwg

a Lacelle
day, June 24, 2014 12:36 PM
hepherd; Mike Petsche; Chris Provencal
rbes
206-642-541 floats

anyone that can answer me:
arplates D4956-XX that replace the D3535-XX are SS unpainted, but the wearpads D3537-1/-3 are painted, does this matter?